



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5522-1
Job Sheet 188588



Part No: D5522-1

Job Qty: 10 pcs

Part Name: Oil Drain Valve Mount



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/11/19

Job Tracking No:

Due Date: 1/28/19

Created By: Jesse White

Type: SOLD

Description:

Note: D5522 REV.C IPP REV:A 17.05.29 NEW ISSUE DD VERF:JFS IPP REV:B 17.11.17 MODIFY PROCESS TO MATCH INTUITIVE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs	1/28/19	1/28/19	0.00	1.00	Bandsaw - 1		JH 19-01-23
110	HAAS 5 Axis - B4B	10 pcs	1/28/19	1/28/19	0.00	5.00	HAAS - 5 - B4B		JH 19-01-31
120	QC 2	10 pcs	1/28/19	1/28/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		JH 19-01-31
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		



Container No: S147261



Part: D5522-1

Job No: 188588

Serial No/Batch: S147261

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/23/19

244
258
190
1.142
H5

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	10 pcs	1/28/19	0.00 0.00	QC 21 - SA - 21	DAS 21 3-29
				QC 21 - SA - 70	MAR 08 2019
Part Op 100 - Bandsaw - Cut blanks at 3.63" Descriptions: 110 - HAAS CNC vertical machine #5 - 1-Machine D5522-1 as per Folio FB540 and Dwg D5522. 2-Deburr 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Small Fab - USE ULTRA SONIC TO CLEAN D5522-1 PART MUST BE DRY INSTALL PLASTIC PUSH-ON CAPS 150 - QC5- Inspect part completeness to step on W/O ***BEFORE PUTTING THE CAPS VERIFY IF THE PART IS CLEAN INSIDE*** 160 - Identify as per dwg & Stock Location: _____ 170 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303B1.500X3.500	303 Bar 1.500" X 3.500"	3 ft (.3 ea)	100-Bandsaw - 1	S119738	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M303B1.500X3.500	3	7	0	
Part Specifications					
Specifications could not be found.					



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Status: New

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Description

Due Date: 1/28/19

Type: SOLD

Note: D5522 REV.C IPP REV:A 17.05.29 NEW ISSUE DD VER
MATCH INTUITIVE DD VERF:JFS

CESS TO

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/28/19	0.00	0.00	Start Up Machining-4		
100	Bandsaw	10 pcs		1/28/19	0.00	1.00	Bandsaw1		
110	CNC Vertical Machining	10 pcs		1/28/19	0.00	5.00	HAAS 5 Axis		
120	QC	10 pcs		1/28/19	0.00	0.00	QC2 Machining-4		
130	QC	10 pcs		1/28/19	0.00	0.00	QC8 Machining-4		
140	Small Fab	10 pcs		1/28/19	0.00	1.00	Small Fab-5		
150	QC	10 pcs		1/28/19	0.00	0.00	QC5		
160	Packaging	10 pcs		1/28/19	0.00	0.00	Packaging3-2		
170	QC21-SA	10 Ea		1/28/19	0.00	0.00	QC21		

Part Op 100 - Cut blanks at 3.63"

Descriptions: 110 - 1-Machine D5522-1 as per Folio FB540 and Dwg D5522. 2-Deburr

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - USE ULTRA SONIC TO CLEAN D5522-1 PART MUST BE DRY INSTALL PLASTIC PUSH-ON CAPS

150 - ***BEFORE PUTTING THE CAPS VERIFY IF THE PART IS CLEAN INSIDE***

160 - Identify as per dwg & Stock Location:

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303B1.500X3.500	303 Bar 1.500" X 3.500"	3 ft (.3 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303B1.500X3.500	3	7	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due	☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	☐ OTHER :	

DART AEROSPACE LTD		Work Order:	188 588
Description: Oil Drain Valve Mount		Part Number:	D5522-1
Inspection Dwg: D5522 Rev: C		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.45	+/- .030	3.450	✓		SLIO	View
2.35	+/- .030	2.351	✓			
3.35	+/- .030	3.350	✓			
2.00	+/- .030	2.000	✓			
1.25	+/- .030	1.249	✓			
R.63	+/- .030	.630	✓		Rad gauge	
.94	+/- .030	.940	✓			
.80	+/- .030	.800	✓			
.80	+/- .030	.801	✓			
R.13	+/- .030	.130	✓		Rad gauge	
2.13	+/- .030	2.130	✓			
R.41	+/- .030	.410	✓		Rad gauge	
R.50	+/- .030	.500	✓		"	
1.22	+/- .030	1.220	✓			
R.50	+/- .030	.500	✓			
.03X45°	+/- .030 X .5°	.042X45°	✓			
1.10	+/- .030	1.102	✓			
.550	+/- .010	.549	✓			
1.18	+/- .030	1.175	✓			
.49	+/- .030	.490	✓			
R.13	+/- .030	.130	✓		Rad gauge	
.125	+/- .010	.126	✓			
.20	+/- .030	.197	✓			
30°	+/- .5°	30°	✓		Protractor	
1.150	+/- .005	1.150	✓			
.600	+/- .010	.597	✓			
45°	+/- .5°	45°	✓		Protractor	
φ .098	+ .004/- .001	.097	✓			
.17	+/- .030	.170	✓			
7/16-20 UNF	—	7/16-20	✓		Thread gauge	
.63 Deep	+/- .030	.630	✓		✓	
7/16-20 UNF	— DAS	7/16-20	✓		Thread gauge	

Measured by:	20 9-89	Checked by:	gmk	QC Inspector:	
Date:	19-01-30	Date:	19/02/02	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

